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U/R

D169-841-015

Job Sheet 187398



Part No: D169-841-015

Job Qty: 1 ea

Part Name: AW169 Lower Cutter

Concession Required



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 12/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 16-692 DWG REV D IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD IPP REV:B 15.07.03 AS
PER CHG002 ecn15-595 DD VERF:JLM

Ship Via:

7265

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/6/18	12/6/18	0.00	0.00	Start Up Stores/Pkg-1		JAN 02 2019
110	Packaging	1 pcs	12/6/18	12/6/18	0.00	0.00	Packaging1-2		JAN 02 2019
120	QC	1 pcs	12/6/18	12/6/18	0.00	0.00	QC4		JAN 02 2019
130	Packaging	1 pcs	12/6/18	12/6/18	0.00	0.00	Packaging1-2		JAN 02 2019
135	DC	1 pcs	12/6/18	12/6/18	0.00	0.00	DC		JAN 02 2019
140	QC21-FG	1 Ea	12/6/18	12/6/18	0.00	0.00	QC21		MAY 31 2019

Part Op 130 - Identify and pack for shipping as per PPP D169-841-015

Descriptions: 135 - "Photocopy bluefiles per D169-841 Cable Cutter System and create labels per 6F9540V00231 CHG002"

Job BOM

Part / Item	Component Name	Quantity	Operation
D4842-041	Lower Cutter Assembly	1 Ea (1 ea)	90-Start up Operation
MS21042L08	Nut	5 Ea (5 ea)	90-Start up Operation
MS27039-08-24	Screw (MS27039-0824)	5 Ea (5 ea)	90-Start up Operation
NAS1149FN832P	Washer	10 Ea (10 ea)	90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4842-041	1	7	0
	MS21042L08	5	1,541	0
	MS27039-08-24	5	179	0
	NAS1149FN832P	10	1,335	0



Container No: S141105



Part: D169-841-015

Job No: 187398

Serial No/Batch: S141105

Revision:

Inspector:

Exp Date:

Instructions: URF 16-692

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Plex 12/4/18 6:20 AM Dart.lajeunesse.marie

Date: 01/02/19

Entered: _____ Date: _____



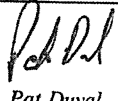
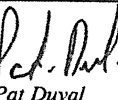
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

		Supplier Concession				PAGE 1 of 2	PLANT Vergiate
Supplier NC N.	AWC-019/00	Date	14.05.2019	AW Concession	400000082381	Purchase Order	4801885188
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue	
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	1,000	Defective Quantity	1,000
AW NC	MARCO FRANCESCONI					A/C Type/Model	AW6
Supplier	DART AEROSPACE LTD					Contract	
Defect MA01 - Items or materials different from requir - S/N S171709							
Cause of Defect				Repetitiveness (same P/N - Defect Code) NO ☐ YES ☒ (7)			
ENGINEERING Evaluation and Proposal							
Engineering Evaluations, including Specialist inputs: * 30.05.2019 17:11:44 MARCELLO STEFANELLI (9273) * The evaluation reported in the annex concession of the supplier are acceptable and applicable. The part can be installed with the repair instruction.				Investigation Report n.		Compliance Report n.	
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B							
Defect effect				Limitations			
	Before Repair		After Repair				
Safety	☐ YES	☐ YES ☐ NO	☐ YES (to specificity) ☒ NO				
Life or Duration	☐ YES	☐ YES ☐ NO					
Strenght	☐ YES	☐ YES ☐ NO					
Performances	☐ YES	☐ YES ☐ NO					
Interchangeability	☐ YES	☐ YES ☐ NO					
Reliability	☐ YES	☐ YES ☐ NO					
Maintainability	☐ YES	☐ YES ☐ NO					
Installability	☒ YES	☐ YES ☒ NO					
Testability	☐ YES	☐ YES ☐ NO					
Only Appearance	☐ YES	☐ YES ☐ NO					
No Effect	☐ YES	☐ YES ☐ NO					
Repair Proposal: * 30.05.2019 17:11:44 MARCELLO STEFANELLI (9273) * See the proposal reported in the attached document of the supplier.				Decision ☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO	
Mark part with Concession		☒ NO ☐ YES		Method :			
ATE	MARCELLO STEFANELLI		CPE			Date	30.05.2019
Checks and tests to be performed							
Repair registration		with repair WO ☒		Number:			
Repair Evaluation:							
Final Decision							
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)
S171709	☐	☒	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
Not Serialized	Use As Is (Q.ty)	Use Repaired (Q.ty)	1,000	Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative	
Signature	MARCELLO STEFANELLI						
Date	30.05.2019						

		CONCESSION				Pag. 1 of 2	
Manuf. Doc. N.	AWC-019	Date	May 10, 2019	AW Doc. N.		Purchase Order	4801885188
AW P/N	6F9540V00231	S/N / Batch Number	S171709	Grade	A	AW Drawing Issue	B
Description	Protector, CCP Lower Assembly			Batch Q.ty	1	Defective Q.ty	
Manufacturer	Dart Aerospace LTD			Model	AW169		
Defect(s) Description							
- Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket - The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019
Defect(s) Cause							
- The Lower Cutter body has a dimension of 0.43 +0.01/-0.00. This dimension was reported as part of the approved FAI and has been met with all delivered product - Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019
Corrective Action						Complete Before	
- In order to mitigate the interference issue for Leonardo, Dart is proposing removing 0.010" (0.254 mm) from each face of the lower cutter body for a total gain of 0.020" (0.508 mm). - Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-16-9-89	 Pat Duval	May 10, 2019